

Title (en)

METHOD FOR FRICTION-STIR WELDING OF STEEL SHEET

Title (de)

VERFAHREN ZUM RÜHRREIBSCHWEISSEN VON STAHLBLECH

Title (fr)

PROCÉDÉ DE SOUDAGE PAR FRICTION-MALAXAGE D'UNE FEUILLE D'ACIER

Publication

**EP 2835209 B1 20160907 (EN)**

Application

**EP 13772114 A 20130404**

Priority

- JP 2012086924 A 20120406
- JP 2013002349 W 20130404

Abstract (en)

[origin: EP2835209A1] When friction-stir welding steel sheets, for the rotating tool, rotation speed RS is set 100-1000 rpm, rotational torque RT 50-500 Nm, and travel speed TS 10-1000 mm/min, and HIPT (kJ/mm<sup>2</sup>) is controlled to be in a range of 0.3-1.5. The steel sheets that are used have a composition including 0.01-0.2 mass% of C, 0.5-2.0 mass% of Mn, 0.6 mass% or less of Si, 0.030 mass% or less of P, 0.015 mass% or less of S, and 0.0060 mass% or less of O, with a content of Ti [%Ti] and a content of N [%N] being restricted in relation to the HIPT, Ceq being 0.5 mass% or less, and the balance being Fe and incidental impurities. As a result, local change in the frictional heat and plastic flow generated by friction can be prevented, yielding a weld portion with uniform and good toughness.

IPC 8 full level

**B23K 20/12** (2006.01); **C22C 38/00** (2006.01); **C22C 38/14** (2006.01); **C22C 38/58** (2006.01)

CPC (source: CN EP US)

**B23K 20/122** (2013.01 - CN EP US); **B23K 20/1255** (2013.01 - CN EP US); **B23K 20/227** (2013.01 - EP US); **B23K 35/3073** (2013.01 - EP US); **C22C 38/00** (2013.01 - EP US); **C22C 38/001** (2013.01 - CN EP US); **C22C 38/002** (2013.01 - CN EP US); **C22C 38/02** (2013.01 - CN EP US); **C22C 38/04** (2013.01 - CN EP US); **C22C 38/06** (2013.01 - CN EP US); **C22C 38/08** (2013.01 - CN EP US); **C22C 38/12** (2013.01 - CN EP US); **C22C 38/14** (2013.01 - CN EP US); **C22C 38/16** (2013.01 - CN EP US); **C22C 38/18** (2013.01 - CN EP US); **C22C 38/42** (2013.01 - EP US); **C22C 38/46** (2013.01 - EP US); **C22C 38/50** (2013.01 - EP US); **B23K 2101/006** (2018.07 - CN EP US); **B23K 2101/18** (2018.07 - CN EP US); **B23K 2103/04** (2018.07 - CN EP US)

Cited by

US12059741B2; US11707798B2; US11130194B2; US11654508B2; EP3900868A4; CN109562485A; EP3498415A4; US11707799B2; WO2022200585A1; US10766099B2; US11654507B2; US11712748B2

Designated contracting state (EPC)

AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

DOCDB simple family (publication)

**EP 2835209 A1 20150211**; **EP 2835209 A4 20150422**; **EP 2835209 B1 20160907**; CA 2869382 A1 20131010; CA 2869382 C 20151020; CN 104203481 A 20141210; CN 104203481 B 20160302; JP 5522316 B2 20140618; JP WO2013150801 A1 20151217; KR 101505381 B1 20150323; KR 20140130735 A 20141111; RU 2569271 C1 20151120; US 2015041521 A1 20150212; WO 2013150801 A1 20131010

DOCDB simple family (application)

**EP 13772114 A 20130404**; CA 2869382 A 20130404; CN 201380018472 A 20130404; JP 2013002349 W 20130404; JP 2013534521 A 20130404; KR 20147027350 A 20130404; RU 2014140178 A 20130404; US 201314390410 A 20130404